

5/50

DART AEROSPACE LTD	Work Order:	24566
Description: End Plate	Part Number:	D3067-1
Drawing: D3067 Rev. A*	Qty:	160 162
		Page 1 of 1

RF 02/10/17

Stack of 8


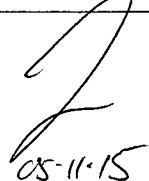

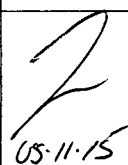
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	MF	05.10.13	160
2	MV	Cut blanks 2.750" x 3.030" +/- 0.005 Grain along 2.750" Material: 5052-H32 (QQ-A-250/8) (M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063) Batch: 4116459	En	05/11/13	160
3	MV	Machine per folio FA183 and Dwg D3067	En	05/11/13	160
4	QC2	Inspect parts as they come off the CNC machine	En	05/11/13	160
5	QC7	Second inspection	En	05/11/13	160
6	MV	Deburr			
7	GB	Bend as per Dwg D3067	SP	05/11/15	162
8	QC5	Inspect work to Step 7		05/11/15	162
9	WA	Identify and stock		05/11/15	162
10	AC	Cost / Part	SAE	05-11-21	162
11	DC	Close W/O Inspect level 21		05-11-21	162


pta

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	EC	
B	02.01.03	Now machined on HAAS	SM	
C	02.10.04	Re-format	KJ RF	
C1	03.01.21	Remove step 6 (Deburr)	RF	

RELEASED
02/10/15 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-11-13	3	16 (2 stacks) moved while machining	 05/11/13	Scrap, destroy and replace.	EN 05/11/17	 05-11-15	 05/11/13	 05-11-15

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/11/13

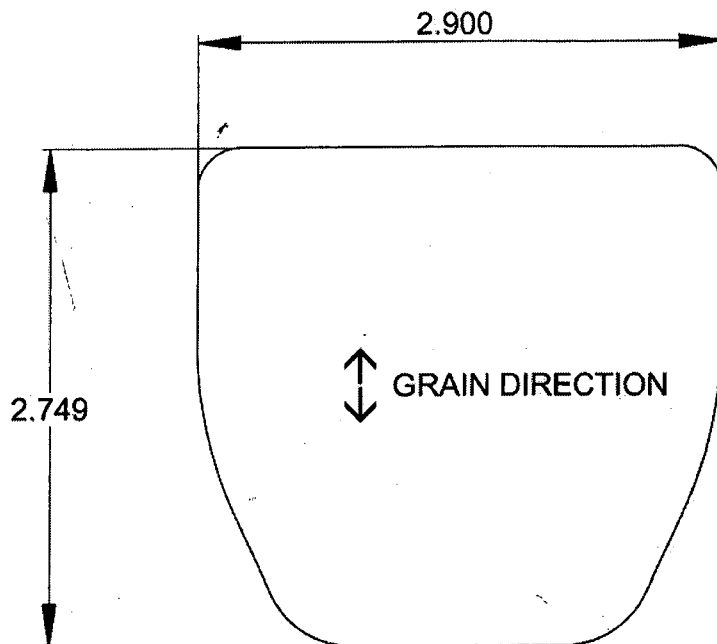
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

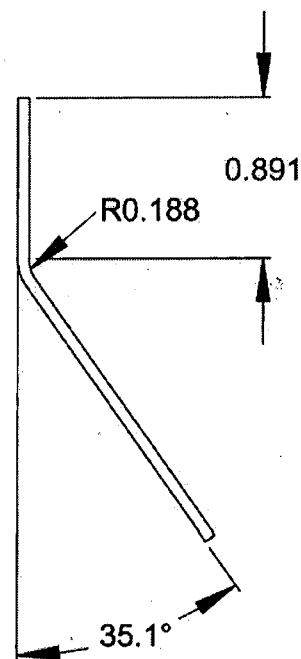


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO
WITHOUT

WORK C

NO. 24566

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 13, 2005
11:58 am

Work Order No : 0024566
Project Name : D3067-1
Project For : WK550
Work Order Type : Main
Main WO Number :
House Part Number : D3067-1
Description : End Plate
Manufactured : Yes
Amount Req'd : 160
Amount Done : 0
Start Date : 10-13-05
Est Finish Date : 12-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Thursday, 11/17/2005 11:51:39 AM
User: Linda Lacelle













Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : END PLATE
Job Number : 24566	
Estimate Number : 10547	
P.O. Number :	Part Number : D30671
This Issue : 11/17/2005 S.O. No. :	Drawing Number : D3067 REV A
Prsht Rev. : NC	Project Number :
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run :	Material :
Written By :	Due Date : 11/24/2005 Qty: 162 Um: Each
Checked & Approved By :	
Comment : Est:03.01.21 Remove step 6 (Deburr) KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S063	5052-H32 .063 Sheet
2.0	SHEAR	SHEAR
 		
Comment: SHEAR Cut blanks 2.750" x 3.030" +/- 0.005 Grain along 2.750"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
 		
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio FA183 and Dwg D3067		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
 		
Comment: SECOND CHECK		
6.0	BRAKE NC	NC BRAKE
 		
Comment: NC BRAKE Bend as per Dwg D3067		
7.0	QC5	INSPECT WORK TO CURRENT STEP
 		
Comment: INSPECT WORK TO NEXT STEP		

Date: Thursday, 11/17/2005 11:51:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END PLATE

Job Number: 24566

Part Number: D30671

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

